

Work Order ID 66732

Friday, February 25, 2011 8:51:02 AM



Page 1

Item ID: DSK077

Accept



Setup Start



Revision ID:

Stop



Item Name: D2892-1 TURNING DETAIL

Start Date: 2/25/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-02-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK077

Rev A

100



Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

Turn blank as per Folio FA082

11/5/14

7

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11/5/14

7

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

11/05/05

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66732

Page 2

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Required Date: 3/11/2011 Req'd Qty: 7.00



Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

0.00

Packaging

Memo

Packaging

Identify and Stock in Kanban Location: MAT 060 SL 4/65/05

140

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

11/5/05
MF
11-05-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 8:51:08 AM

Page 1
1

Work Order ID: 66732



Parent Item: DSK077



Parent Item Name: D2892-1 TURNING DETAIL



Start Date: 2/25/2011

Required Date: 3/11/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-003  Round Billet, 17-4		Manufactured	No				Each	9.0000		7 51		11/5/13	

Location

Loc Qty

Loc Code

MAT43

9

53750

3

60943

6

1
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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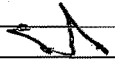

NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order:	46732
Description: Turning Detail for D2892-1		Part Number:	DSK077
Inspection Dwg: DSK077	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.528	2.524	2.527	2.522	2.524
B	3.702	3.722		3.714	3.712	3.712	3.712	3.712
C	2.814	2.834		2.824	2.824	2.823	2.823	2.823
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.099	.099	.100	.100	.100
F	2.714	2.734		2.723	2.723	2.723	2.723	2.723
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	3.214	3.234		3.225	3.224	3.224	3.224	3.224
I	0.913	0.933		.923	.923	.923	.923	.923
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.099	.099	.099	.099	.099
L								
M								
N								
O								
P								

Measured by:		Date:	11/5/9
Audited by:		Date:	11/05/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	66732
Description: Turning Detail for D2892-1		Part Number:	DSK077
Inspection Dwg: DSK077 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.524	2.529		2.526	2.527			
B	3.702	3.722		3.713	3.711			
C	2.814	2.834		2.828	2.828			
D	0.718	0.738		.728	.728			
E	0.090	0.110		.100	.100			
F	2.714	2.734		2.723	2.723			
G	2.029	2.049		2.039	2.039			
H	3.214	3.234		3.228	3.228			
I	0.913	0.933		.923	.923			
J	0.022	0.042		.031	.031			
K	0.090	0.110		.100	.079			
L								
M								
N								
O								
P								

Measured by:	SL	Date:	11/5/14
Audited by:	SL	Date:	11/05/15
Prototype Approval:		Date:	

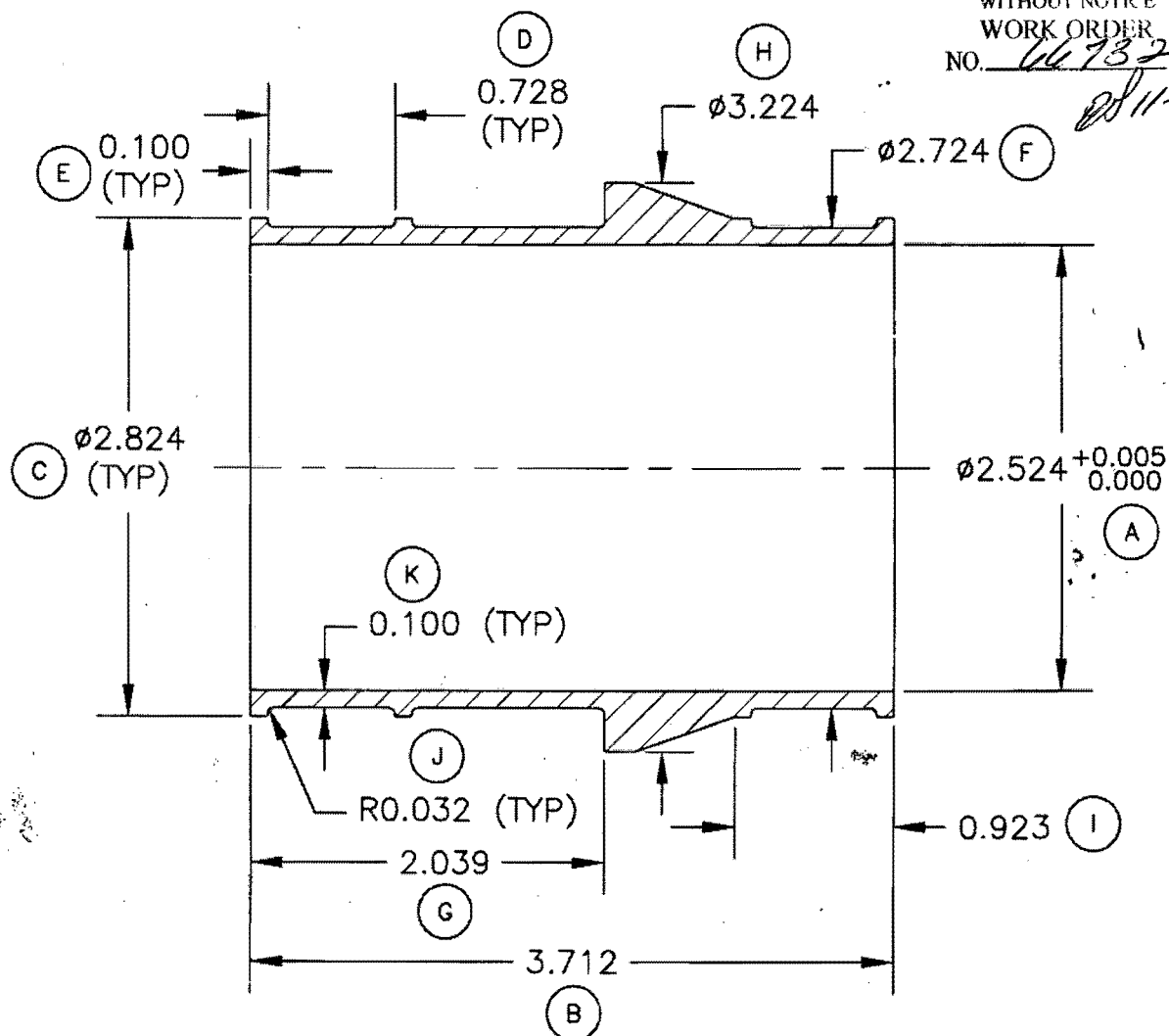
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SL



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 077	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2892-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66732
08/11-0225



D2892-1 TURNING DETAIL

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